INSTRUCTION MANUAL FOR

RUGER®
SIDE-BY-SIDE SHOTGUNS

12 GAUGE

Gold Label

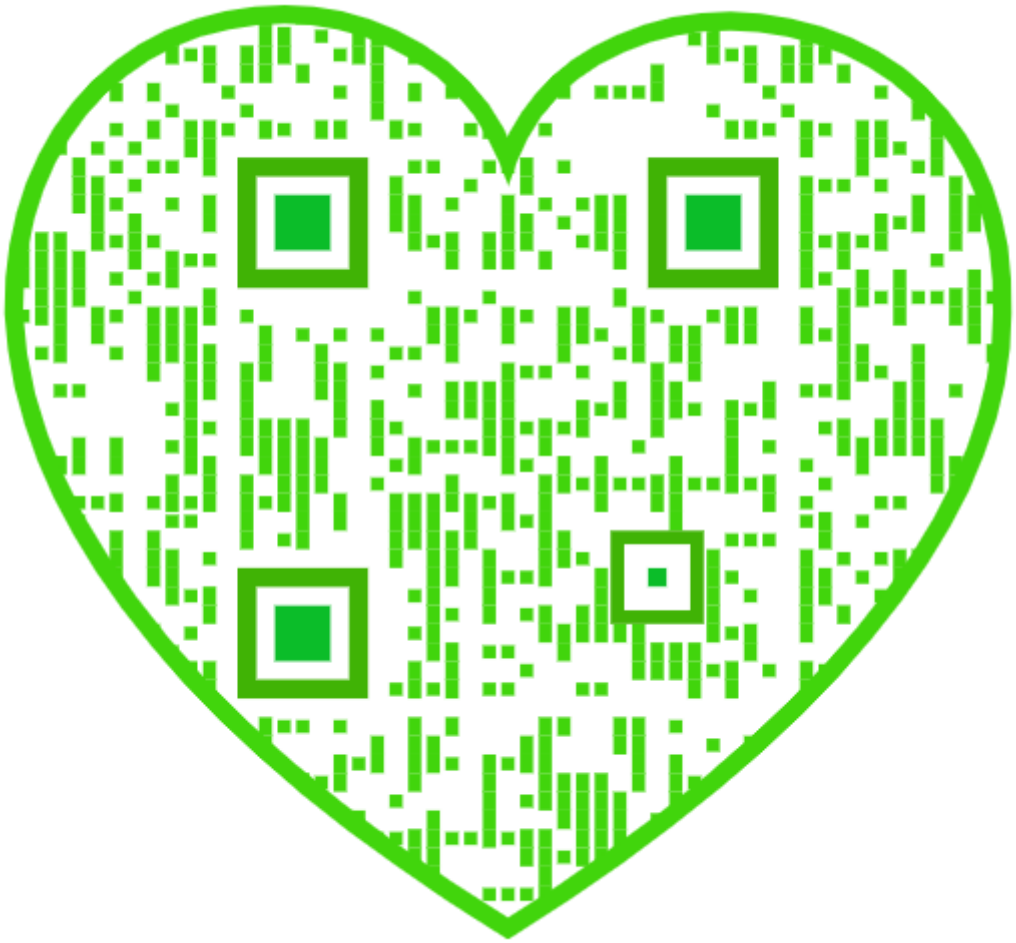
READ THE INSTRUCTIONS AND WARNINGS IN THIS MANUAL CAREFULLY BEFORE USING THIS FIREARM

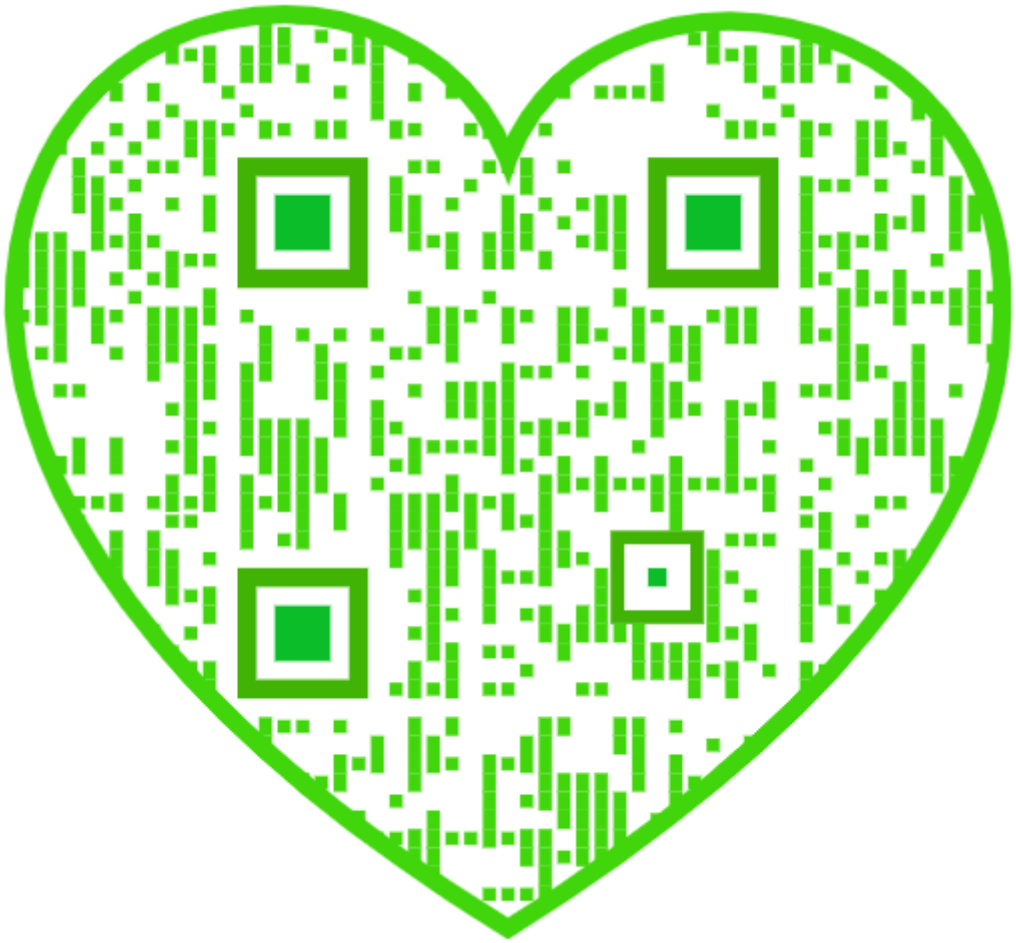
For Product Service on This Model Please Call:
(603) 865-2442 (See p. 27)

STURM, RUGER & Company, Inc.
Southport, Connecticut 06890 U.S.A.

THIS INSTRUCTION MANUAL SHOULD ALWAYS ACCOMPANY THIS FIREARM AND BE TRANSFERRED WITH IT UPON CHANGE OF OWNERSHIP, OR WHEN THE FIREARM IS LOANED OR PRESENTED TO ANOTHER PERSON.

KSXS/9-02





State-By-State Warnings

Certain states require by law that their own specified warning notices in larger-than-normal type be conspicuously included by the manufacturer, distributor, or retail dealer with firearms sold in that state. Sturm, Ruger sells its products in compliance with applicable laws and regulations. Because our products may be sold in these states, we include the following:

California:

⚠ WARNING	⚠ ADVERTENCIA
"Children are attracted to and can operate firearms that can cause severe injuries or death. Prevent child access by always keeping guns locked away and unloaded when not in use. If you keep a loaded firearm where a child obtains and improperly uses it, you can be fined or sent to prison."	"A los niños los atraen las armas de fuego y las pueden hacer funcionar. Ellos pueden causarses lesions graves y la muerte. Evite que los niños tengan accesso a las armas de fuego guardándolas siempre con llave y descargadas cuando no las esté utilizando. Si usted tiene un arma de fuego cargada en un lugar en que un niño tiene acceso a ella y la usa indebidamente, le pueden dar una multa o enviarlo a la carcel."

Connecticut:

"UNLAWFUL STORAGE OF A LOADED FIREARM MAY RESULT IN IMPRISONMENT OR FINE."

Florida:

"IT IS UNLAWFUL, AND PUNISHABLE BY IMPRISONMENT AND FINE, FOR ANY ADULT TO STORE OR LEAVE A FIREARM IN ANY PLACE WITHIN THE REACH OR EASY ACCESS OF A MINOR UNDER 18 YEARS OF AGE OR TO KNOWINGLY SELL OR OTHERWISE TRANSFER OWNERSHIP OR POSSESSION OF A FIREARM TO A MINOR OR A PERSON OF UNSOUND MIND."

Maine:

"ENDANGERING THE WELFARE OF A CHILD IS A CRIME. IF YOU LEAVE A FIREARM AND AMMUNITION WITHIN EASY ACCESS OF A CHILD, YOU MAY BE SUBJECT TO FINE, IMPRISONMENT OR BOTH. KEEP FIREARMS AND AMMUNITION SEPARATE. KEEP FIREARMS AND AMMUNITION LOCKED UP. USE TRIGGER LOCKS."

Maryland:

"WARNING: Children can operate firearms which may cause death or serious injury. It is a crime to store or leave a loaded firearm in any location where an individual knew or should have known that an unsupervised minor would gain access to the firearm. Store your firearm responsibly!"

Massachusetts:

"WARNING FROM THE MASSACHUSETTS ATTORNEY GENERAL: This handgun is not equipped with a device that fully blocks use by unauthorized users. More than 200,000 firearms like this one are stolen from their owners every year in the United States. In addition, there are more than a thousand suicides each year by younger children and teenagers who get access to firearms. Hundreds more die from accidental discharge. It is likely that many more children sustain serious wounds, or inflict such wounds accidentally on others. In order to limit the chance of such misuse, it is imperative that you keep this weapon locked in a secure place and take other steps necessary to limit the possibility of theft or accident. Failure to take reasonable preventive steps may result in innocent lives being lost, and in some circumstances may result in your liability for these deaths."

"IT IS UNLAWFUL TO STORE OR KEEP A FIREARM, RIFLE, SHOTGUN OR MACHINE GUN IN ANY PLACE UNLESS THAT WEAPON IS EQUIPPED WITH A TAMPER-RESISTANT SAFETY DEVICE OR IS STORED OR KEPT IN A SECURELY LOCKED CONTAINER."

New Jersey:

"IT IS A CRIMINAL OFFENSE TO LEAVE A LOADED FIREARM WITHIN EASY ACCESS OF A MINOR."

New York City:

"THE USE OF A LOCKING DEVICE OR SAFETY LOCK IS ONLY ONE ASPECT OF RESPONSIBLE WEAPONS STORAGE. ALL WEAPONS SHOULD BE STORED UNLOADED AND LOCKED IN A LOCATION THAT IS BOTH SEPARATE FROM THEIR AMMUNITION AND INACCESSIBLE TO CHILDREN AND ANY OTHER UNAUTHORIZED PERSONS."

North Carolina:

"IT IS UNLAWFUL TO STORE OR LEAVE A FIREARM THAT CAN BE DISCHARGED IN A MANNER THAT A REASONABLE PERSON SHOULD KNOW IS ACCESSIBLE TO A MINOR."

Texas:

"IT IS UNLAWFUL TO STORE, TRANSPORT, OR ABANDON AN UNSECURED FIREARM IN A PLACE WHERE CHILDREN ARE LIKELY TO BE AND CAN OBTAIN ACCESS TO THE FIREARM."

Wisconsin:

"IF YOU LEAVE A LOADED FIREARM WITHIN THE REACH OR EASY ACCESS OF A CHILD YOU MAY BE FINED OR IMPRISONED OR BOTH IF THE CHILD IMPROPERLY DISCHARGES, POSSESSES, OR EXHIBITS THE FIREARM."

* *

Please check with your licensed retailer or state police for additional warnings which may be required by local law or regulation. Such regulations change constantly, and local authorities are in the best position to advise you on such legal matters.

LOCKING DEVICE
INSTALLATION INSTRUCTIONS

⚠ WARNING – USE OF LOCKING DEVICES

- Always keep your firearm pointed in a safe direction, including when you are installing or removing your locking device.
- Always verify that your firearm is completely **unloaded** before installing your locking device.
- Do not install locking devices in the trigger guard; always keep your fingers, clamp and locking device outside the trigger guard during device installation and removal.
- Store firearms, ammunition and keys separately and securely, away from children and careless adults; do not store your firearm with the keys in the locking device.
- Do not attempt to work the action of your firearm with the locking device in place; this may damage your firearm.
- While locking devices are an important aid to security measures, they are not a substitute for safe firearm handling and proper storage. Remember that any mechanical device can be bypassed with enough time, knowledge, determination and equipment.

LOCKING DEVICES MUST BE USED SAFELY AND RESPONSIBLY

Use the Correct Lock: While the basic locking device is substantially similar for all Ruger® firearms, due to the different shapes of the many Ruger® firearms, different firearms utilize different locking devices. The locking device for your ***SIDE-BY-SIDE SHOTGUN*** includes a 2 1/2" lock and a clamp (black metal bracket to which the lock is applied.)

To Install the Factory-Supplied Locking Device:

1. Keep the muzzle pointed in a safe direction and your fingers outside the trigger guard at all times!
2. Be sure the firearm is completely unloaded and contains no cartridges or cartridge cases!
3. Disassemble the shotgun into the stock-receiver assembly and barrel-forend assembly. (This procedure is described on page 23 of this manual.)

4. Apply the clamp to the stock-receiver assembly as show in Figure 1.
5. Apply the lock to the clamp by inserting the shackle of the lock into the holes in the clamp as shown in Figure 2.
6. Close the lock by pressing the shackle into the body of the lock (the part that receives the key) as tightly together as possible. The lock has bumpers and the shackle is coated with a non-marring material that will not harm the metal finish of your firearm; be careful not to dent or scratch the wooden stock.
7. Once the lock is securely closed, turn the key to its locked position and remove it. Pull firmly on the shackle and lock to test connection and be sure it is locked. Do not leave or store your firearm with the key in the lock! Store your locked unloaded firearm and the key in secure, separate locations, away from ammunition, children, or unauthorized adults.

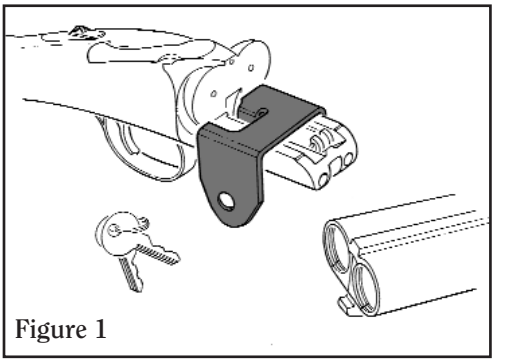


Figure 1

Correct Installation of Clamp

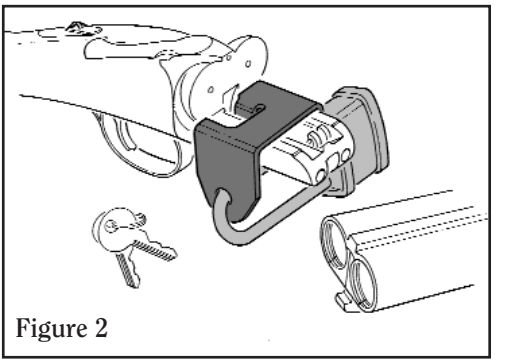


Figure 2

Correct Installation of Lock through Clamp
For Ruger Side By Side Shotgun Only

FIREARMS SAFETY-YOUR RESPONSIBILITY

SAFETY MUST BE THE FIRST AND CONSTANT CONSIDERATION OF EVERY PERSON WHO HANDLES FIREARMS AND AMMUNITION.

This Instruction Manual is designed to assist you in learning how to use and care for your ***RUGER® SIDE-BY-SIDE SHOTGUN*** properly. Please contact us if you have any questions about it.

Only when you are certain you fully understand the Manual and can properly carry out its instructions should you practice loading, etc. with live ammunition. If you have any doubts about your ability to handle or use a particular type of gun safely, then you should seek supervised instruction. Such personalized instruction is often available from gun dealers, gun clubs or police departments. If none of these sources can help you, write to the National Rifle Association, 11250 Waples Mill Rd., Fairfax, VA 22030-7400. They will assist you.

The person possessing a gun has a full-time job. You cannot guess; you cannot forget. You must know how to use your firearm safely. Do not use any firearm without having a complete understanding of its particular characteristics and safe use. Remember: There is no such thing as a foolproof gun.

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WARNINGS OF GREAT IMPORTANCE ARE FOUND ON THE FOLLOWING PAGES:

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OTHER CAUTIONS AND WARNINGS APPEAR THROUGHOUT THE MANUAL.

**FIREARMS ARE DANGEROUS WEAPONS–
READ THE INSTRUCTIONS AND WARNINGS
IN THIS MANUAL THOROUGHLY AND
CAREFULLY BEFORE USING.**

WARNING–ALTERATIONS

This product was designed to function properly in its original condition. Alterations can make it unsafe. Do not alter any part or add or substitute parts or accessories not made by Sturm, Ruger & Co. Inc.

DO NOT ALTER ANY GUN

GENERAL INFORMATION AND MECHANICAL CHARACTERISTICS

The ***RUGER® GOLD LABEL SIDE-BY-SIDE SHOTGUN*** is a two-shot, double barreled, lightweight shotgun. It comes with "screw-in" choke tubes of various degrees of choke, a single selective trigger, and selective ejectors.

THE SAFETY MECHANISMS

The trigger mechanism includes a ***hammer interrupter*** which directly blocks the hammers if either or both are cocked and the safety is engaged. With the safety off, the hammer interrupter can be lifted clear of the hammers only by a deliberate pull of the trigger. A complete release of the trigger is necessary to set the gun for firing the second shot. The automatic safety mounted on top of the receiver also serves as the barrel selector that determines which of the two barrels is to be fired first. The conical pointed firing pins are strongly proportioned and will not be damaged by dry-firing.

The ***sliding safety thumbpiece***, in addition to its fore and aft motion, pivots to swing from side to side and thus incorporates the function of ***barrel selector*** in association with the single trigger mechanism. In its rear, or "safe" position, the

safety mechanism locks the ***hammer interrupter*** – a unique characteristic of this gun. In this position, it is impossible for the hammers to reach the firing pins. The hammer interrupter, in turn, locks the trigger against being pulled. The sequence of firing is set with the safety in its rearmost "safe" position. If the thumbpiece is swung to its left side position and pushed forward, an "R" is visible and the selector allows the right barrel to be fired first. If the thumbpiece is swung to the right side and pushed forward, an "L" is visible and the selector allows the left barrel to be fired first.

Under recoil, an inertia weight swings to the rear and pulls the sear selector out of engagement with the sears. The sear selector is inoperative until the inertia weight returns to its forward position, so the gun is thus made safe from "doubling" (firing both barrels with a single pull of the trigger). This mechanism has the desirable feature of permitting the second barrel to be discharged even if the first pull of the trigger results in a misfire. The second shot can be fired whether the gun has recoiled or not.

The ***hammers*** are of the rebounding type. After firing, they move back from the firing pins enough to clear then and are held in this position by the mainspring. The rebound position of the hammers means that their cocking motion is not started until after the barrels are partially opened, and this contributes materially to the easy opening of the gun. The hammers cannot fall completely forward to reach the firing pins unless the locking bolt, which lies directly ahead of them, is in its forward position when the barrels are locked shut in the frame.

THE BARREL ASSEMBLY

The lightweight ***barrels*** are silver brazed to the monobloc at the chamber portion of the barrel. The rib is securely soldered to the barrels and machine-cut cross serrations in the top surface of the rib provide a matte, glare-free sighting plane. The front sight is a standard gold bead.

A massive ***square lug*** at the bottom rear of the monobloc locks into the thick bottom wall of the receiver to provide extra security for the barrel-to-frame lock-up.

Projecting from the rear end of the monobloc is a heavy, integral heat-treated ***lug*** which is engaged by the locking bolt as it slides forward when the gun is closed. The locking bolt is, in effect, a wedge, due to the angle of the locking face. The face has more than adequate area and is hardened and precision-ground.

The ***automatic ejectors*** assemble to the monobloc simply, with a retaining screw. The ***ejector strikers*** are "selective" in that only fired shells are ejected when the barrels are fully opened. (See "Unloading Warning", p. 21)

THE WOOD

The stock and forearm are made from high grade American walnut, fully seasoned, with deep-cut checkering of 22 lines to the inch. A straight grip and synthetic buttplate are standard on all models. All wood surfaces are sealed with a satin weather-resistant finish.

Provision is made in the stock for the ***through-bolt*** system of attachment which is strong and simple. The rear ends of the tangs interlock with the wood and the forward end of the stock is tenoned into recesses in the receiver to provide maximum strength and resistance to splitting or loosening.

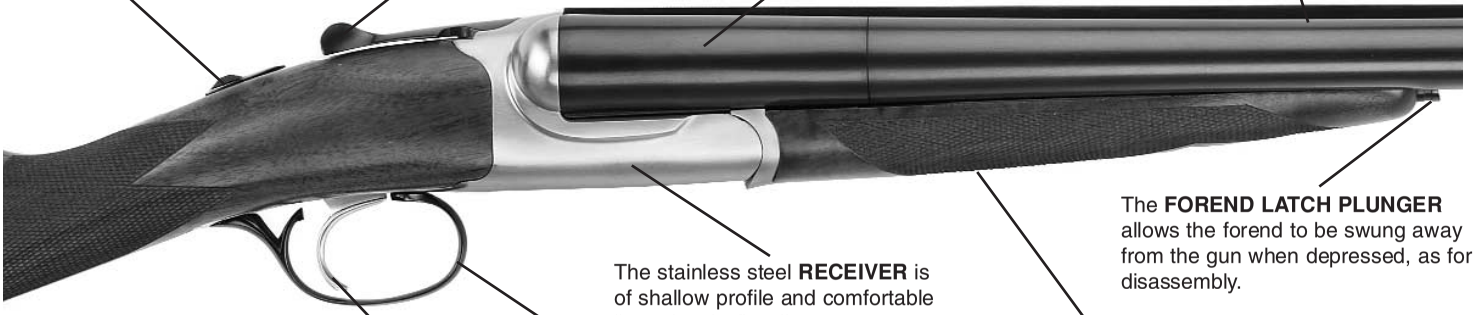
NOMENCLATURE

The **SAFETY**, in addition to its fore and aft motion, pivots to swing from side to side when on "safe" (S) and incorporates the function of barrel selector. If the selector is swung to its left side position the right barrel fires first. If the selector is to the right, the left barrel fires first. In its rearmost "safe" position, the safety locks the hammer interrupter. In this position it is impossible for the hammer to reach the firing pin and the trigger cannot be pulled.

The **TOP LEVER** and its pivot directly engage the locking bolt on both opening and closing motions.

The solid **RIB** is securely fastened to the barrels for quick target alignment.

The **MONOBLOC** joins the barrels at the rear and supports the 3" chambers.



The **FOREND LATCH PLUNGER** allows the forend to be swung away from the gun when depressed, as for disassembly.

The stainless steel **RECEIVER** is of shallow profile and comfortable "round action" styling.

The **FOREND**, like the buttstock, is of finely checkered high-grade walnut.

The **BUTTSTOCK** is held on the gun by a long through-bolt, which is accessible only after the butt plate on the end of the buttstock is removed.

The single-selective **TRIGGER** fires the selected barrel when pulled with the safety in the forward "Fire" position.

The steel **TRIGGER GUARD** protects the trigger from inadvertent blows. Fingers should always be kept outside the trigger guard except when actually firing.

Figure 3

SPECIAL FEATURES

The ***RUGER® 12 GAUGE SIDE-BY-SIDE*** shotguns are offered with stainless steel receivers. The trigger and forend iron are made of stainless steel with an attractive brushed finish. The trigger guard, top lever, and safety thumbpiece, as well as barrels, are of heat-treated chrome-molybdenum steel, polished overall and blued.

The top lever and its pivot directly engage the locking bolt both on opening and closing motions. The lever and the locking bolt are driven to the closed position by the top lever spring which, through its strut, retains the top lever in the gun. The Ruger shotgun has been engineered to minimize the force required for cocking.

OPERATION OF SAFETY

The ***RUGER® SIDE-BY-SIDE SHOTGUN*** has a safety selector combined with a barrel selector for convenient use. The safety selector is located at the top rear of the receiver.

The safety selector can be moved from the "Fire" position to its "Safe" position whether or not the mechanism is cocked. Fully opening the shotgun cocks the mechanism. The action can be opened with the safety "on."

Whenever the action is opened, the safety automatically moves rearward to its "on," or "Safe" position (the letter 'S' visible forward of the safety thumbpiece on the top surface of the receiver). If the safety thumbpiece is moved forward to cover the letter 'S', the safety is in its "off" or "Fire" position and remains in that position until moved back to the "Safe" position manually, or until the action is opened again. Keep the safety "on" unless actually firing!

BARREL SELECTION

The letters "L" and "R" appear to the right and left of the safety thumbpiece, and indicate which barrel is to fire first. **NOTE:** The safety must be "on" (letter 'S' visible, safety moved to rearmost position) before the barrel selector feature can be used. You cannot change the barrel firing sequence while the safety is "off." If the thumbpiece is then moved to the left so that the letter "R" appears, the right barrel will fire first when the safety is pushed forward and the trigger is pulled. If the thumbpiece is moved to the right when the safety is on so that the letter "L" appears, the left barrel will fire first when the safety is pushed forward and the trigger is pulled. See page 13.

Do not attempt to select barrels between shots! Once you have fired one barrel, the other will automatically be the next one to fire when you pull the trigger. If you only fire one shot and wish to reload, simply break open the gun, eject the fired shell, reload the chamber, and close the gun. The automatic safety will have engaged, and you can now select either barrel for your next shot. Keep the safety "ON" (S) until you are actually firing on a selected target.

Practice (with an unloaded shotgun) moving the safety/barrel selector to the three positions until you know the position of the safety selector for the three modes – Safe (S), Fire left barrel first (L), and Fire right barrel first (R). WARNING: When manipulating the safety selector, DO NOT HAVE ANY FINGER INSIDE THE TRIGGER GUARD! Whenever the safety selector is in the "Fire" position and the trigger is pulled, the shotgun will fire.

The safety selector should always be in the "Safe" (S) position except when the gun user is actually firing. The safety selector should unfailingly be moved to the "Safe" (S) position when the gun user ceases firing, even for a moment.

SAFETY/BARREL SELECTOR POSITIONS

The safety selector should be moved to the "Safe" (S) position and kept there unless the gun is to be fired immediately.

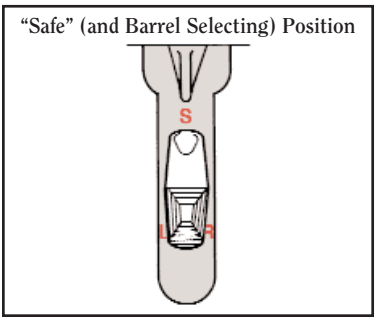


Figure 4. Safety selector in "Safe" (S) full rearward position. The safety selector must be in this position to select position 'L' or 'R' described below. In this position, the trigger cannot be pulled to fire the gun. Either 'L' or 'R' may be partially visible, but the shotgun is only on "Safe" when the 'S' is fully exposed. If the 'S' is not visible, the shotgun is ready to fire!

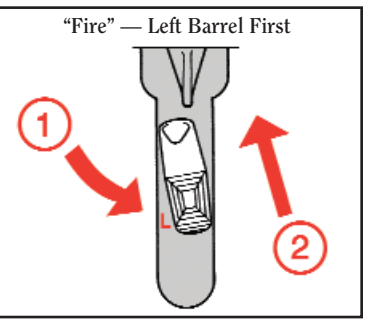


Figure 5. Safety selector is forward "Fire Left Barrel (L) First" position. Pulling the trigger will fire the left barrel – a second pull of the trigger will then fire the right barrel. It is not necessary to select between shots. The safety selector should be moved to this position only when the gun user is actually firing.

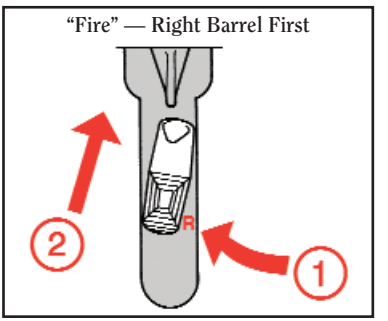
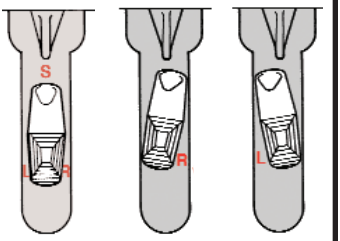


Figure 6. Safety selector in forward "Fire Right Barrel (R) First" position. Pulling the trigger will fire the right barrel – a second pull will then fire the left barrel. It is not necessary to select between shots. The safety selector should be in this position only when the gun user is actually firing.

When the safety is in either fire position, it is referred to as being "off." (When the safety is in the "Safe" (S) position, it is referred to as being "on".)

WARNING – SAFETY SELECTOR



"SAFE" "FIRE" RIGHT BBL. FIRST "FIRE" LEFT BBL. FIRST

Keep the safety on unless actually firing. Always move the safety fully to its intended position and check it. The safety has three positions – "SAFE" (S), "FIRE (L) LEFT Barrel-FIRST" and "FIRE (R) RIGHT Barrel - FIRST". Never depend on a safety mechanism or any other mechanical device to justify careless handling or permitting the shotgun to point in an unsafe direction. The only "safe" gun is one in which the action is open and the chambers are empty.

KNOW HOW TO USE THE SAFETY

This safety selector is held in each of its three positions by a plunger that is under spring tension. Therefore, the gun user should frequently check the position of the safety selector to be certain it has not been inadvertently moved. If the safety selector seems to move too easily, or if the safety selector does not seem firmly positioned in any of its three positions, the shotgun should be discontinued from use and returned to our Newport, New Hampshire Product Service Department for repair.

AMMUNITION

The Ruger 12 gauge Gold Label Side-by-Side Shotguns have 3" chambers and may be used with all standard commercially manufactured 2 3/4" and 3" shot shells. This gun has been tested with special proof test ammunition which conforms to U.S. industry practice. It is intended for use only with standard ammunition of the proper gauge and loading. Use of incorrect ammunition can destroy any gun and result in serious injury to the shooter or bystanders. (See "Ammunition Warning," p. 15)

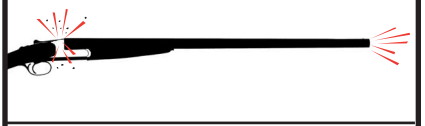
STEEL SHOT

All steel shot loads loaded to current U.S. industry specifications can be used in currently manufactured Ruger shotguns equipped with screw-in chokes, including the Ruger Gold Label Side-By-Side shotgun. Some older Ruger "Red Label" Over and Under shotguns were manufactured with conventional fixed chokes. In conventionally choked full choke barrels without screw-in choke tubes, the use of large size (F, T, BB and larger) steel shot can result in a very slight ring near the muzzle. It must be emphasized that this ring should have no adverse effect on pattern or shot velocity. As we have no control over the manufacture of ammunition which may be introduced in the future, we cannot be responsible for damage caused by steel shot loads.

Since steel shot generally patterns tighter than conventional lead shot loads, it would be wise to avoid the use of steel shot altogether in conventionally choked "full choke" barrels. Modified choke barrels generally deliver "full choke" patterns when used with steel shot.

We do not recommend ***any*** of our shotguns for use with ***reloads***, steel shot or otherwise.

WARNING – AMMUNITION



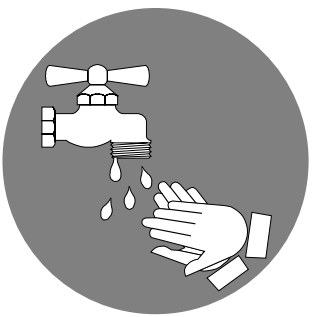
Death, serious injury, and damage can result from the use of wrong ammunition, bore obstructions, powder overloads, or incorrect cartridge components. Always wear shooting glasses and hearing protectors.

IMPROPER AMMUNITION DESTROYS GUNS

AMMUNITION (CARTRIDGES) NOTICE

WE SPECIFICALLY DISCLAIM RESPONSIBILITY FOR ANY DAMAGE OR INJURY WHATSOEVER OCCURING IN CONNECTION WITH, OR AS A RESULT OF, THE USE IN ANY RUGER FIREARMS OF FAULTY, OR NON-STANDARD, OR "REMANUFACTURED" OR HAND-LOADED (RELOADED) AMMUNITION, OR OF CARTRIDGES OTHER THAN THOSE FOR WHICH THE FIREARM WAS ORIGINALLY CHAMBERED.

WARNING – LEAD EXPOSURE



Discharging firearms in poorly ventilated areas, cleaning firearms, or handling ammunition may result in exposure to lead and other substances known to the state of California to cause birth defects, reproductive harm, and other serious physical injury. Have adequate ventilation at all times. Wash hands thoroughly after exposure.

SHOOTING OR CLEANING GUNS MAY EXPOSE YOU TO LEAD

ASSEMBLING THE SHOTGUN

The Ruger Gold Label Side-By-Side Shotgun is shipped partially disassembled. To assemble, proceed as follows:

1. After unwrapping the barrel/forearm assembly and receiver/stock assembly, wipe excess rust preventative oil from the monobloc and inside surfaces of the receiver. Swab the bores with a clean cloth patch on a cleaning rod to remove any excess oil.

2. To Correctly Remove Forend (See Figure 7):
   a. Unlatch forend by pressing in the forend latch plunger at tip of forend.
   b. Carefully pull down on tip of forearm until slight resistance is felt - APPLICATION OF EXCESSIVE FORCE AT THIS POINT CAN RESULT IN BREAKAGE.
   c. While holding forearm tip away from barrels, carefully pull forearm toward the muzzle and remove forearm from barrels.

   Do not attempt to attach barrel assembly to receiver with the forend attached!

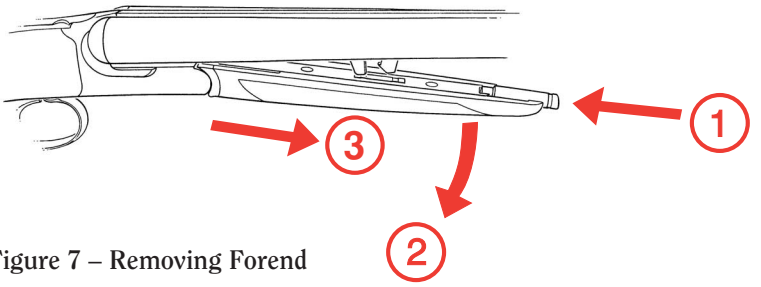
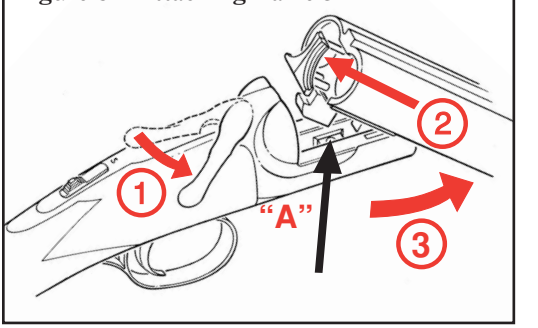


Figure 7 – Removing Forend

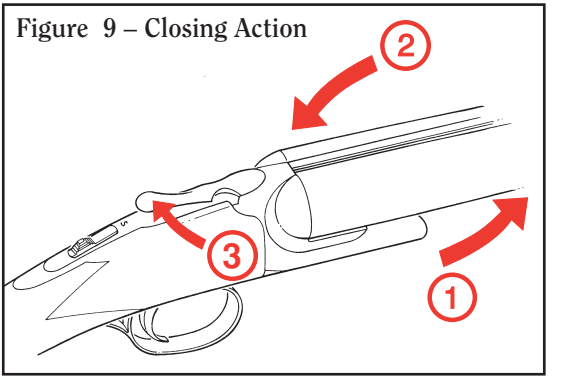
3. To attach the barrel assembly to the receiver, hold the stock by the pistol grip in one hand as shown in Figure 8. Make sure the top lever is opened to the right in order to accept the barrel assembly. Hold the barrel assembly in the other hand, make sure both ejectors are fully extended from the chambers, and engage the hinge pin in the receiver with the corresponding recesses at the front end of the monobloc. Be sure the small lug (indicated by the arrow in "A" in Figure 8.) on the outer surfaces of the ejectors engage the corresponding slot inside the front end of the receiver *BEFORE CLOSING THE GUN! The foregoing caution must be followed otherwise the receiver will be damaged by the ejectors as the gun is closed.*

Figure 8 – Attaching Barrels



4. Swing the muzzle end of the barrels upward, pivoting the rear end of the monobloc downward to seat in the receiver as shown in Figure 9. The barrel assembly is seated and locked into the receiver when the top lever snaps to its centered position.

Figure 9 – Closing Action



5. Place the rear end of the forend iron against the receiver as shown in Figure 10, and swing the front end of the forearm upward until the forend latch lever aligns with the forend latch hook on the underside of the lower barrel. Depress the forend latch and carefully snap the forend assembly up into its locked position.

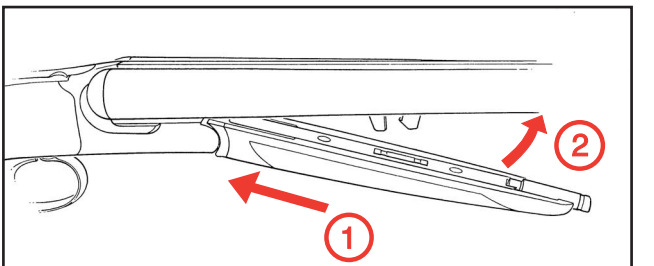
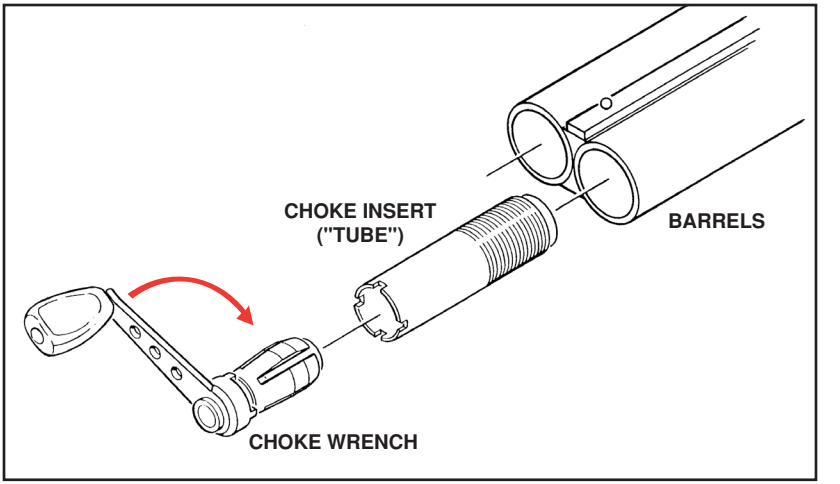


Figure 10 – Attaching Forend

INSTALLATION OF SCREW-IN CHOKES

Make sure the shotgun is unloaded! Either open the action or dismount the barrels completely from the action assembly. Lightly coat the threads of both the barrel and the desired choke insert with good quality gun oil. Carefully start the choke insert into the barrel threads by hand, taking care that the choke insert is not cross-threaded. Using the choke wrench (supplied), carefully hand tighten the choke insert into the barrel until it is tightly secured in the barrel, and so that the choke insert is fully bottomed into its recess in the barrel. Take note which choke you are inserting into each barrel. The choke inserts are stamped either "FULL', "MODIFIED", "IMPROVED CYLINDER", or "SKEET". Remove the choke wrench from the barrel after tightening.



NOTE: ***Stainless Steel*** choke inserts may protrude slightly from muzzle when fully seated. This is normal and helps protect the muzzle of the barrel from damage.

To minimize the possibility of damage to the screw-in choke inserts and the barrel threads, it is recommended that a set of choke inserts be kept correctly tightened into the barrel at all times, including storage and cleaning. Cleaning the barrels without the choke inserts in place can push dirt and other fouling into the barrel threads, which will interfere with proper installation of the choke inserts.

Rifled and Saboted Slugs — Do not fire slugs unless a choke insert is installed (see "Screw-In choke Warnings", p. 19). It is recommended that you do not fire slugs through a full choke insert.

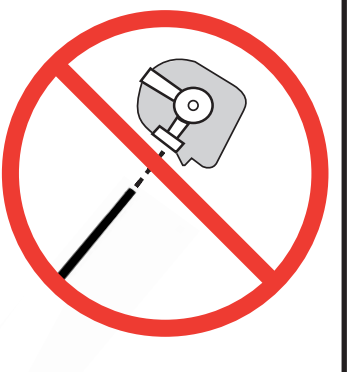
Steel Shot — Steel shot loads manufactured to U.S. Industry Standards can be used with Ruger Screw-in choke inserts with no special precautions other than those listed above and on page 14.

Please Note that the relatively lightweight barrels of this model you have chosen for its fast handling and ease of carrying, and their corresponding thinner choke tubes, require that the user take precautions to avoid abusive mishandling of the shotgun against hard objects that could cause dents or other deformation. This is a characteristic of all lightweight shotgun barrels and choke tubes. If such denting or deformation occurs, contact our Product Service Department immediately to have the shotgun repaired. Never use any gun with dented or deformed parts! See page 27.

Be sure you only use the correct choke inserts (tubes). Ruger Side-By-Side choke tubes are **not** interchangeable with any other Ruger shotgun chokes, including those designed for our Red Label Over-and-Under shotguns. Screw-in choke inserts are stainless steel and stamped on the side either "FULL", "MODIFIED", "IMPROVED CYLINDER", or "SKEET". A general rule of thumb is that if the choke tubes screw in significantly below flush with the muzzle, or if the chokes stick more than slightly out of the muzzle when completely tightened, you are either using the wrong choke tubes or you have incorrectly installed them.

Never fire the shotgun without the screw-in choke inserts in place. Doing so will cause an erratic shot pattern and may irreversibly damage the choke insert threads in the barrel, making correct installation of the screw-in choke inserts impossible without expensive re-barreling. Do not attempt to use screw-in choke tubes of any other make or manufacture in Ruger shotguns. They will not function properly.

⚠ WARNING – SCREW-IN CHOKES



Do not peer directly into the shotgun muzzles! This is dangerous and unnecessary. Do not change choke inserts in a loaded shotgun, regardless of the position of the safety. Never fire the shotgun if the screw-in choke inserts are not fully and tightly bottomed into the barrel threads, or if the inserts are improperly installed or "cross-threaded", or if the threads of either the barrel or the choke insert are damaged. Under these conditions, the barrel will be damaged and the screw-in choke inserts can be propelled out of the muzzle with great velocity when the gun is fired, with resultant risks of property damage or injury to the shooter or bystanders. Do not attempt to alter or modify existing fixed choke Ruger shotgun barrels for screw-in choke inserts. This can seriously weaken the barrel and may be dangerous. See "Alteration Warning" elsewhere in instruction manual.

DO NOT PEER INTO MUZZLES OR CHANGE TUBES ON A LOADED SHOTGUN

OPERATION OF THE SHOTGUN

Always check to be sure the gun is unloaded before handling, "dry-firing", take-down, cleaning or storage.

Every Ruger Shotgun is inspected before shipment to ensure that it conforms to our standards of finish and performance. WE ASSUME NO RESPONSIBILITY FOR ANY INJURY OR DAMAGES RESULTING FROM ITS INTENTIONAL OR ACCIDENTAL DISCHARGE. No mechanism can prevent injury caused by careless or thoughtless handling of a loaded firearm.

TO LOAD AND FIRE

Practice the important aspects of gun handling described below (with an unloaded gun) until you can perform each of the steps with skill and confidence. But before loading the shotgun, please read completely through this manual, and be certain the muzzle is pointing in a safe direction. Do not load the shotgun until you are ready to use it!

1. With the gun assembled, move the top lever completely to the right and open the action completely. The ejectors snap rearward with a "click" to their extended position if their barrels have been fired; otherwise, they will simply move slowly rearward as if to extract but not eject an unfired cartridge. Make sure that the safety has moved rearward to the safe (S) position.
2. Look through the barrels from the rear to be sure that both barrels are completely free from any obstruction (See Rule 4, p. 35).
3. With the gun opened, insert a shot shell of the proper gauge in each chamber.
4. Close the action and check to be sure it is securely locked and that the top lever has moved fully to its centered position. Keep the gun pointed in a safe direction and the safety on 'S'. You may now select which barrel you prefer to fire first by moving the barrel selector either to the right ("R") or the left ("L"). Most shooters fire the more open-choked barrel first, followed by a tighter choke, if a second shot is necessary at a target that is moving away from the shooter.
5. Only when you are ready to fire immediately, move the top safety thumbpiece forward to its "off", or "fire" position. The gun is now ready to fire.

WARNING: DO NOT TOUCH THE TRIGGER UNTIL YOU ARE READY TO FIRE.

6. Pulling the trigger will fire the barrel you have selected to fire first — "L" (left) or "R" (right).
7. After firing the first barrel, the trigger must be allowed to return to its fully forward position to permit firing the second barrel. Simply pull the trigger again to fire the second barrel. It will fire regardless of a failure to fire in the first barrel or if you have failed to load a cartridge into the chamber of the first barrel, since the Ruger shotgun trigger mechanism does not depend upon the recoil of the first shot to "set" the second barrel for firing (as on some competing shotguns). Remember that you should not attempt to pivot the barrel selector between shots – the second barrel is automatically selected to fire on the next pull of the trigger.
8. If a second shot is not to be fired immediately, return the safety to its rearmost "S" position. The shotgun may be opened by pushing the top lever fully to the right and swinging the barrels downward. Any remaining live shells will be raised by the extractors and can be manually extracted; and fired shell cases will be automatically ejected when the barrels are fully opened. This is the preferred safe carrying position for break-open shotguns. Always be certain that the shotgun is pointed in a safe direction!

WARNING – FIRING

All persons must be a safe distance to the rear of the shooter when a shotgun is being fired. Particles of shot, lead, powder, lubricant, accumulated bore deposits and particles of clay targets can be blown in a wide area – particularly if the wind is blowing – into the eyes and face of the shooter and those nearby. For that reason shooters and bystanders must wear shooting glasses or similar eye protection. Hearing protection must also be worn because exposure to shooting noise can damage hearing.

ALWAYS WEAR EYE AND HEARING PROTECTION

TO UNLOAD

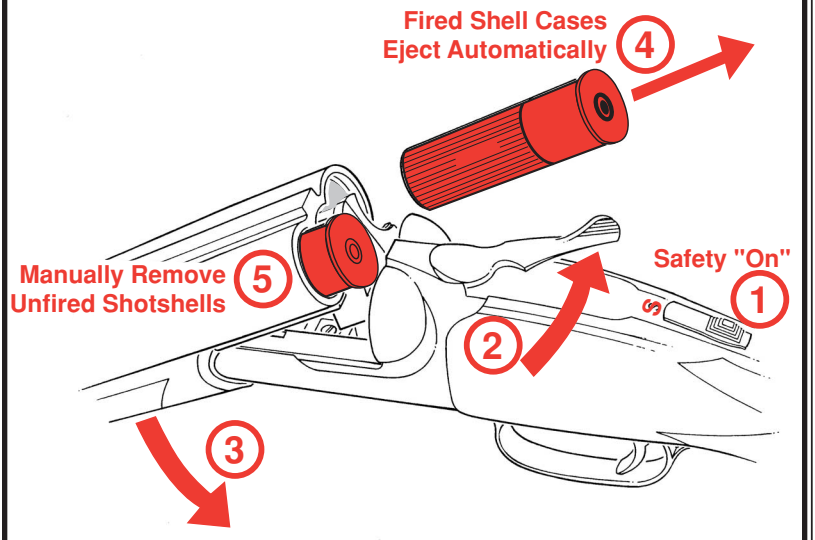
WARNING – UNLOADING

So that the gun can be conveniently reloaded after firing one shot, the selective ejector mechanism only ejects fired shells. It does not eject live ammunition. Do not rely upon the ejector mechanism to unload the gun. Simply opening the gun does not unload it. To unload, open gun smartly, manually remove all cartridges, and visually check both chambers to be sure both chambers are unloaded.

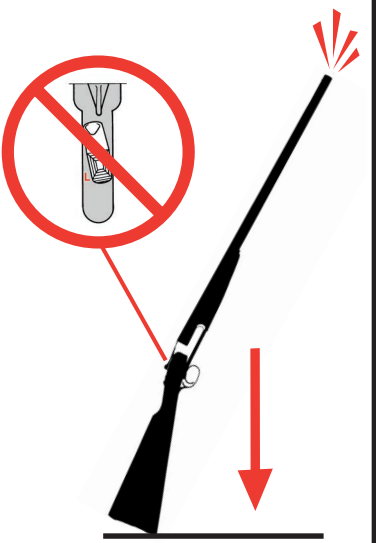
MAKE SURE GUN IS UNLOADED

After firing, move the safety to the 'S' position, move the top lever completely to the right, and pivot the barrels downward to open the action and eject the empty shot shells. Vigorously opening the barrels downward will assist in ejecting empty shells. If the action is opened with unfired shot shells in the chambers, they will be elevated (but not ejected) sufficiently to be easily extracted with the fingers. You must remove live (unfired) cartridges manually! Visually inspect both chambers to be sure the shotgun is completely unloaded prior to closing the action when you are finished shooting.

CORRECT UNLOADING SEQUENCE



WARNING – HANDLING

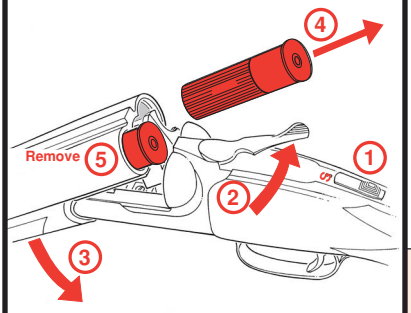


Never carry the shotgun loaded with the safety "off". Never place a loaded gun against any object (wall, fence, vehicle, tree, etc.) because there is always the possibility that the gun will be knocked or jarred from its standing position and fall with sufficient force to be discharged. Keep the safety on (S) unless actually firing. Never point the gun at another person, or allow the muzzle to point at any part of your body, whether the safety is on or not. The only safe gun is one in which the action is open and unloaded.

ANY GUN MAY FIRE IF DROPPED

DISASSEMBLY PROCEDURE

WARNING – DISASSEMBLY



Never clean, lubricate, disassemble or work on a firearm while it is loaded.

UNLOAD BEFORE DISASSEMBLY

To take down (disassemble) the Ruger Side-By-Side Shotgun, proceed as follows:

1. Check both chambers to be sure that the gun is *unloaded.*
2. Press in the forend latch plunger tip and separate the forend assembly from the barrels as in Step 2, page 16 (See Figure 7, p. 16).
3. Push the top lever all the way to the right and open the gun, pivoting the muzzle end of the barrels downward and lifting the barrel assembly out of the receiver as the hinge pin is disengaged from the corresponding recess at the front end of the monobloc.
4. Replace the forend assembly onto the barrel assembly by aligning the forend latch hook with the forend latch lever. Depress the forend latch plunger fully and carefully snap the forend fully upward into place against the underside of the barrels.

This completes the takedown required for all normal cleaning and maintenance purposes. *Further disassembly of component parts should only be undertaken by persons qualified in shotgun repair and is not recommended.*

CAUTION: THE RUGER SIDE BY SIDE SHOTGUN SHOULD NOT BE FURTHER DISASSEMBLED BY PERSONS UNQUALIFIED IN SHOTGUN REPAIR. IMPROPER FUNCTIONING AND DAMAGE TO THE GUN MAY RESULT.

IF THE BUTT STOCK IS REMOVED FROM THE FIREARM, UPON REASSEMBLY, IT MUST BE RETORQUED TO A MAXIMUM OF 4 FT/LBS. EXCESSIVE TIGHTENING OF THE STOCK BOLT (PART S-37), MAY RESULT IN THE STOCK CRACKING.

CARE AND CLEANING

WARNING: BEFORE CLEANING, BE CERTAIN THAT BOTH CHAMBERS OF THE SHOTGUN CONTAIN NO CARTRIDGES

Always check to be sure the gun is completely ***unloaded*** before cleaning.

1. Take down the gun. (See Disassembly Procedure, p. 23)
2. Using a proper cleaning rod, run a solvent-wetted patch through each bore several times. Then run dry patches through the bore to remove all traces of residue. The bore, as referred to here, includes the chamber.
3. If the bore is leaded to the extent that the above patch-cleaning procedure will not remove the lead or plastic residue, then scrub the bore, full length, with a solvent-wetted brass-bristle brush. When the leading has been scrubbed loose, clean as described in Step 2 above.
4. The polished surfaces of the monobloc, ejectors, and inside surfaces of the receiver where the monobloc rests should be coated with a very light film of lubricating oil.
5. Reassemble the gun, and wipe exterior metal surfaces with a sparingly oiled cloth. Accumulation of oil tends to attract dirt which can interfere with the safe and reliable function of the gun. Swab the bores with an oily patch before storing the gun. ***Do not apply excess oil.***

WARNING – LUBRICATION

Firing a shotgun with oil, grease, or any other material even partially obstructing the bore may result in damage to the shotgun and serious injury to the shooter and those nearby. Do not spray or apply lubricants directly on shot shells. If the shot shell charge is affected by the lubricant, it may not be ignited, but the primer firing may push shot or wads into the bore where they may be lodged. Firing a subsequent shot into the obstructed bore may damage the gun and cause serious injury or death to the shooter and those nearby. Use lubricants properly. You are responsible for the proper care and maintenance of your firearms.

IMPROPER LUBRICATION DESTROYS GUNS

PERIODIC MAINTENANCE – At regular intervals, or whenever the gun has been exposed to sand, dust, extreme humidity, condensation, immersion in water, or other adverse conditions, take down and clean and oil as outlined above. Lubricate contact area of forend iron and receiver with Stainless steel lubricant. Proper periodic maintenance is essential to the reliable functioning of any firearm.

STORAGE

GUNS SHOULD NOT BE STORED LOADED!

USE THE LOCKING DEVICE SUPPLIED WITH THE SHOTGUN FOR STORAGE.
(SEE PAGE 6)

Do not store the shotgun in a leather case or scabbard. Leather attracts moisture, even though the case may appear to be perfectly dry.

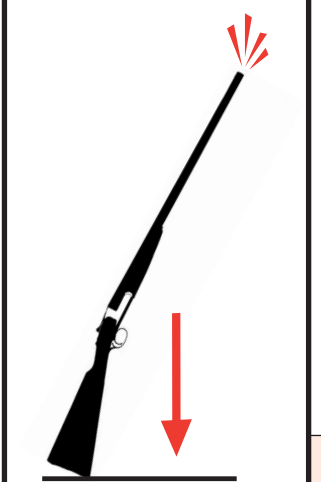
TO RENDER THE SHOTGUN INOPERATIVE FOR SAFE STORAGE

Open the action and check both chambers to be sure the shotgun is completely unloaded! With the muzzle pointed in a safe direction, close the barrel assembly fully. Turn the shotgun over and depress the forend plunger tip. Carefully remove the forend from the barrel assembly. Next, turn the shotgun over and press the barrel opening lever fully to the right. Swing the barrel assembly downward and then carefully remove it form the receiver. Assemble the forend to the barrel assembly.

Store the shotgun stock-receiver assembly and the barrel-forend assembly in different locations. When disassembled in this manner, the shotgun is inoperable. It is impossible to fire the shotgun until the barrel assembly has been correctly reattached to the receiver assembly.

To reassemble the shotgun for firing, carefully remove the forend from the barrel assembly. Carefully replace the barrel assembly into the receiver and carefully swing the barrels shut. Now replace the forend onto the barrel assembly. Press the barrel opening lever fully to the right and break the shotgun open. The shotgun is now reassembled and can be loaded and fired normally.

WARNING – STORAGE



Never place or store any firearm in such a manner that it may be dislodged. Firearms should always be stored securely and unloaded, away from children and careless adults. Use the locking device supplied with the rifle for storage.

The use of a locking device or safety lock is only one aspect of responsible firearms storage. For increased safety, firearms should be stored unloaded in a location that is both separate from their ammunition and inaccessible to children and any other unauthorized person.

STORE SECURELY & UNLOADED

While the shotgun is less likely to be used by unauthorized persons when disassembled in the above manner, it is always safest to store any firearm with the supplied locking device correctly installed, or to store the firearm in a gun safe or other secure location away from children and unauthorized adults. Guns should always be stored securely, unloaded and separate from their ammunition.

MAINTENANCE OF STAINLESS STEEL COMPONENTS

Firearms and components made of stainless steel are relatively more resistant to corrosion than those of blued steel. However, in the interest of proper operation and long life of a stainless steel firearm, inspect it frequently and clean, lubricate and apply an appropriate rust preventative.

Sometimes discoloration occurs from perspiration or from contact with some types of gun cases. Rusting may occur as a result of the firearm being exposed to moisture, salt air or chemicals.

Minor discoloration can usually be removed by rubbing the stainless steel area with an abrasive ink eraser, crocus cloth, or a "metal polishing" compound. When using any of these abrasives, proceed with care and use light pressure to achieve a blending of "color" with those areas that are not discolored.

External surfaces most subject to rusting from handling, or from exposure to the elements should be cleaned and wiped dry after use or after exposure to adverse conditions. If the shotgun is to be stored, coat it with a light film of oil or preservative. Where the shotgun is in continuing use, and the presence of oil or grease would be objectionable, then the external surfaces can be coated (after cleaning and drying) with a paste wax formulated for use on metals. Apply the wax sparingly, allow time for it to dry hard, then buff lightly with a soft cloth. When applying the wax, take care that it does not get into the mechanism or on the functioning parts or in the bore.

SERVICE AND PARTS POLICY

If you have any question with regard to the performance of your ***RUGER® SIDE-BY-SIDE SHOTGUN*** please write or call (603-865-2442) our Product Service Department, 411 Sunapee Street, Newport, New Hampshire 03773, fully describing all circumstances and conditions involved. If you should return your shotgun to the factory for repair, or order parts for it, please comply with the following suggestions for prompt service.

WARNING: BEFORE SHIPPING ANY FIREARM, BE ABSOLUTELY CERTAIN THAT IT IS UNLOADED. DO NOT SHIP CARTRIDGES WITH A FIREARM.

SHIPPING FIREARMS FOR REPAIR

RUGER® SIDE-BY-SIDE SHOTGUNS returned to the factory for repair should be sent to: Sturm, Ruger & Company, Inc., Product Service Department, 411 Sunapee Street, Newport, New Hampshire 03773. Telephone (603) 865-2442. Guns should be sent prepaid. We will not accept collect shipments.

The Federal Gun Control Act, as well as the law of most States and localities, does not prohibit an individual (who is not otherwise barred from purchasing or possessing a firearm) from shipping a firearm directly to the manufacturer for repair. However, before you ship your shotgun to us, be certain that your State or locality does not have a law or regulation which will prohibit you from receiving the shotgun from us after it has been repaired. If such receiving is prohibited, then please have a Federally Licensed firearms dealer ship the gun to us. If your shotgun is sent to us by a dealer, it will be returned to him after being repaired. If a handgun (pistol or revolver) is shipped by an individual who does not hold a Federal Firearms License, it must be shipped via U.P.S. (Next Day Air) Persons who do not hold a Federal Firearms License are prohibited by Federal law from shipping a handgun by Mail. Handguns mailed in violation of the law are impounded by the Post Office.

Please do not include your carrying case, scabbard, or custom accessories with a firearm being shipped to the factory for service. **DO NOT SEND GUN BOXES OR LITERATURE THAT YOU CONSIDER TO BE COLLECTOR'S ITEMS – THESE ARE INVARIABLY DAMAGED OR DESTROYED IN SHIPMENT.** Rifles and shotguns may be shipped via Parcel Post. Always insure your shipment.

Enclose a letter which includes your name, address, telephone number, serial number and model of the firearm. Describe in detail the trouble you have experienced with your firearm, or the work you wish to have done. Merely stating that the firearm "needs repair" is inadequate information.

Work performed will bear a net minimum labor charge of $20.00 plus a $12.00 shipping and handling charge. The charge for rebluing the ***RUGER® SIDE-BY-SIDE SHOTGUN*** is $75.00 plus a $12.00 shipping and handling charge. Custom gunsmithing service or nonstandard alterations are NOT AVAILABLE from Ruger Product Service Departments.

WARNING – PARTS PURCHASERS

It is the purchaser's responsibility to be absolutely certain that any parts ordered from the factory are correctly fitted and installed. Firearms are complicated mechanisms and IMPROPER FITTING OF PARTS MAY RESULT IN A DANGEROUS MALFUNCTION, DAMAGE TO THE FIREARM, AND SERIOUS INJURY TO THE SHOOTER AND OTHER PERSONS. The purchaser and installer of parts must accept full responsibility for the correct adjustment and functioning of the shotgun after such installation.

PARTS MUST FIT CORRECTLY

ORDERING PARTS

Please contact the New Hampshire Product Service Department for parts availability and current prices. All parts orders for the ***RUGER® SIDE-BY-SIDE SHOTGUN*** should be sent to: Sturm, Ruger & Company, Inc., Product Service Department, 411 Sunapee Street, Newport, New Hampshire 03773, (603) 865-2442. We cannot comply with open account or C.O.D. requests. Payment in the form of a check, money order, Visa or Mastercard must accompany your order. Credit Card orders must include the account number, expiration date and whether it is a Visa or Mastercard account. Minimum parts order is $1.00 plus a $3.50 shipping and handling charge. Order parts by Part Number and Part Name and include the entire serial number of the firearm for which the parts are being ordered. There is a minimum net labor charge of $20.00 if the parts are factory fitted. All factory-fitted parts are fitted on an exchange basis only. We will not return the replaced parts.

Barrels and a number of other component parts must be fitted at the factory. Company policy is to proof-test and/or function fire all barrels after fitting to the receivers in which they are to be used. This procedure ensures maximum protection to our customers. The special proof-test ammunition used in this testing is sold only to bonafide firearms manufacturers and is not available to gun shops, gunsmiths, or individuals.

Because the receiver of the ***RUGER® SIDE-BY-SIDE SHOTGUN*** is defined as a "firearm" by Federal Law, it is not offered for sale as a separate component part.

*Parts designated by an asterisk must be factory fitted. These parts are fitted on an exchange basis only. We will not return the replaced parts. We will not return any part that is broken, malfunctioning, badly worn or has been modified. See "Warning – Parts Purchasers" above.

CAUTION: A GUN CONTAINING MODIFIED, BROKEN, MALFUNCTIONING, OR BADLY WORN PARTS SHOULD NOT BE FIRED.

RUGER® SIDE-BY-SIDE SHOTGUNS

PARTS LIST

Design, prices and specifications subject to change without notice.

SPECIFY MODEL AND GAUGE WHEN ORDERING

(See Exploded View on Page 33.)

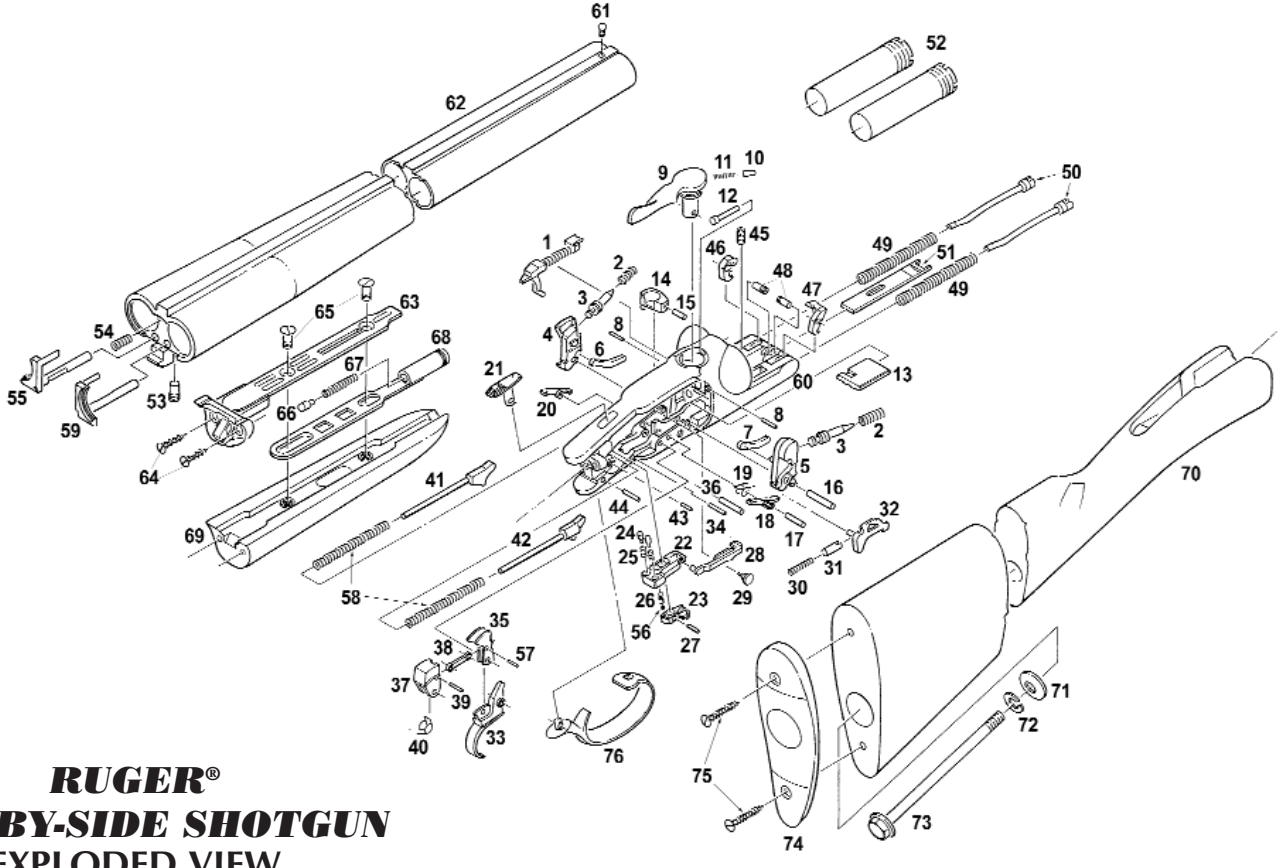
	Number	Part No.	Part Name	Model
	1	KSXS60001	Top Lever Spring Strut Assembly	Side-By-Side
	2	OU-12	Firng Pin Spring, 2 Req'd	Side-By-Side
*	3	OU-11-12	Firing Pin, 2 Req'd	Side-By-Side
*	4	KSXS01701	Hammer, Left	Side-By-Side
*	5	KSXS01703	Hammer, Right	Side-By-Side
	6	KSXS01502	Cocking Strut	Side-By-Side
	7	KSXS01502	Cocking Strut	Side-By-Side
	8	OU-51	Firing Pin Retaining Pin, 2 Req'd	Side-By-Side
*	9	SXS0601	Top Lever	Side-By-Side
	10	OU-72	Top Lever Trip Plunger	Side-By-Side
	11	OU-73	Top Lever Trip Plunger Spring	Side-By-Side
	12	SXS07102	Top Lever Trip Pin	Side-By-Side
*	13	KSXS00901	Locking Bolt	Side-By-Side
*	14	KSXS00903	Locking Bolt Actuator	Side-By-Side
	15	D-26	Trigger Housing Cross Pin	Side-By-Side
	16	OU-43	Hammer Pivot Pin	Side-By-Side
	17	OU-21	Trigger Sear Pivot Pin	Side-By-Side
*	18	KOU02304	Sear, Right	Side-By-Side
*	19	OU-42	Sear Spring	Side-By-Side
*	20	KOU02302	Sear, Left	Side-By-Side
*	21	SXS03203	Safety Thumbpiece	Side-By-Side

	Number	Part No.	Part Name	Model
*	22	KSXS05201	Safety Block	Side-By-Side
*	23	KSXS03301	Safety Extension	Side-By-Side
	24	OU-39	Safety Detent Plunger, 2 Req'd	Side-By-Side
	25	OU-54	Safety Detent Spring, 2 Req'd	Side-By-Side
	26	KSXS03000	Safety Detent Spring	Side-By-Side
	27	KE-55	Trigger Guard Plunger Cross Pin	Side-By-Side
*	28	KSXS04900	Blocking Bar	Side-By-Side
	29	OU-36	Blocking Bar Retaining Pin	Side-By-Side
	30	OU-83	Interruptor Plunger Spring	Side-By-Side
	31	OU-85	Interruptor Plunger	Side-By-Side
*	32	KOU07503	Hammer Interruptor	Side-By-Side
*	33	KSXS00020	Trigger	Side-By-Side
	34	S-31	Roll Pin	Side-By-Side
	35	KOU-16	Sear Selector	Side-By-Side
	36	OU-21	Trigger Sear Pivot Pin	Side-By-Side
	37	KOU-53	Inertia Weight	Side-By-Side
	38	OU-64	Link	Side-By-Side
	39	OU-66	Sear Selector Pivot Pin	Side-By-Side
	40	OU-58	Inertia Weight Spring	Side-By-Side
*	41	KOU90008	Hammer Strut Assembly, Left	Side-By-Side
*	42	KOU90007	Hammer Strut Assembly, Right	Side-By-Side
	43	OU-51	Inertia Weight Pivot Pin	Side-By-Side
	44	S-31	Roll Pin	Side-By-Side
	45	KSXS01502	Cocking Bar Retaining Screw	Side-By-Side

	Number	Part No.	Part Name	Model
	46	KSXS00801	Ejector Kicker, Left	Side-By-Side
	47	KSXS00803	Ejector Kicker, Right	Side-By-Side
	48	KSXS00808	Ejector Kicker Pivot Screw, 2 Req'd	Side-By-Side
	49	SXS00806	Ejector Striker Spring, 2 Req'd	Side-By-Side
	50	SXS00805	Ejector Striker, 2 Req'd	Side-By-Side
*	51	KSXS03000	Cocking Bar	Side-By-Side
	52	KSXS08910A	Choke Insert, Full	Side-By-Side
		KSXS08911A	Choke Insert, Modified	Side-By-Side
		KSXS08912A	Choke Insert, Improved	Side-By-Side
		KSXS08913A	Choke Insert, Skeet	Side-By-Side
		OU09020A	Choke Wrench, Not Illustrated	Side-By-Side
	53	SXS01403	Extractor Retainer	Side-By-Side
	54	KMS04600	Bolt Lock Plunger Spring	Side-By-Side
	55	KSXS21400	Extractor Assembly, Left	Side-By-Side
	56	KSXS03001	Safety Detent Ball	Side-By-Side
	57	KE-55	Trigger Guard Plunger Cross Pin	Side-By-Side
	58	OU-18	Hammer Spring, 2 Req'd.	Side-By-Side
	59	KSXS31400	Extractor Assembly, Right	Side-By-Side
	60	KSXS00104	Frame/Tang Weldment – Not Offered For Sale w/ two KSXS00105 Bushings	Side-By-Side
	61	OU-67	Front Sight Bead	Side-By-Side
*	62	SXS50000B	Barrel Assembly	Side-By-Side
*	63	KSXS17900	Forend Iron Assembly	Side-By-Side
	64	KSXS02600	Forend Iron Head Screw	Side-By-Side

	Number	Part No.	Part Name	Model
	65	KSXS04800	Forend Iron Screw	Side-By-Side
	66	SXS00701	Latch Bar Plunger	Side-By-Side
	67	SXS00703	Latch Bar Spring	Side-By-Side
	68	SXS12800	Latch Bar & Latch Tip Assembly	Side-By-Side
*	69	SXS00500M	Forend Assembly	Side-By-Side
*	70	SXS00402A	Butt Stock	Side-By-Side
	71	S-38	Stock Bolt Washer	Side-By-Side
	72	OU09101	Stock Bolt Lock Washer	Side-By-Side
	73	S-37	Stock Bolt	Side-By-Side
	74	C-90-SM	Butt Plate	Side-By-Side
	75	OU09105	Butt Plate Screws, 2 Req'd.	Side-By-Side
*	76	OU-2	Trigger Guard	Side-By-Side

* PARTS SO MARKED MUST BE FACTORY FITTED



RUGER®
SIDE-BY-SIDE SHOTGUN
EXPLODED VIEW

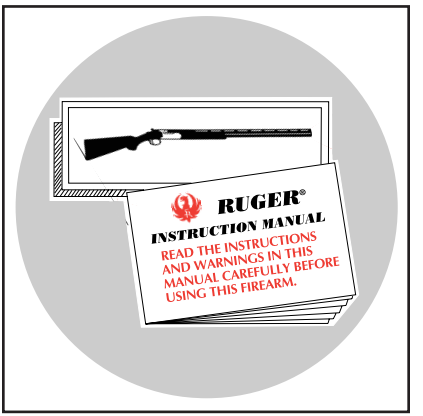
THE BASIC RULES OF SAFE FIREARMS HANDLING

We believe that Americans have a right to purchase and use firearms for lawful purposes. The private ownership of firearms in America is traditional, but that ownership imposes the responsibility on the gun owner to use his firearms in a way which will ensure his own safety and that of others. When firearms are used in a safe and responsible manner, they are a great source of pleasure and satisfaction, and represent a fundamental part of our personal liberty.

Firearms do not cause accidents! Firearms accidents are almost always found to have been the result of carelessness, or ignorance on the part of the shooter of the basic rules of safe gun handling.

The following rules must be observed by gun users at all times. Safe gun handling is not just desirable, it is absolutely essential to your safety, the safety of others, and the continuation of gun ownership and sport shooting as we know it today.

1. LEARN THE MECHANICAL AND HANDLING CHARACTERISTICS OF THE FIREARM YOU ARE USING.



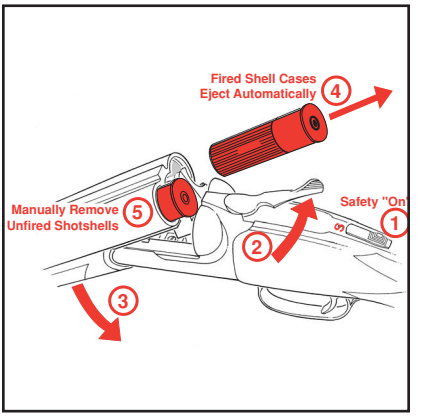
Not all firearms are the same. The method of carrying and handling firearms varies in accordance with the mechanical provisions for avoiding accidental discharge and the various proper procedures for loading and unloading. No person should handle any firearm without first having thoroughly familiarized himself with the particular type of firearm he is using, and with safe gun handling in general.

2. ALWAYS KEEP THE MUZZLE POINTED IN A SAFE DIRECTION.

Be sure of the bullet stop behind your target, even when dry-firing. Never let the muzzle of a firearm point at any part of your body or at another person. This is particularly important when loading or unloading a firearm. In the event of an accidental discharge, no injury can occur as long as the muzzle is pointing in a safe direction. A safe direction means a direction which will not permit a discharged bullet to strike a person, or to strike an object from which the bullet may ricochet.

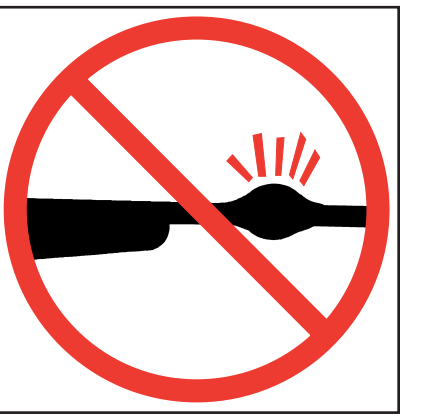
A safe direction must take into account the fact that a bullet may penetrate a wall, ceiling, floor, window, etc., and strike a person or damage property. Make it a habit to know exactly where the muzzle of your gun is pointing whenever you handle it, and be sure that you are always in control of the direction in which the muzzle is pointing, even if you fall or stumble. Keep your finger off the trigger until you are ready to shoot.

3. FIREARMS SHOULD BE UNLOADED WHEN NOT IN USE.



Firearms should be loaded only when you are in the field or on the target range or shooting area, ready to shoot. Firearms and ammunition should be securely locked in safes, racks or cabinets, or by using the locking device supplied with the firearm, when not in use. Ammunition should safely be stored separate from firearms. Store your firearms out of sight of visitors and children. It is the gun owner's responsibility to be certain that children and persons unfamiliar with firearms cannot gain access to firearms, ammunition, or components.

4. BE SURE THE BARREL IS CLEAR OF OBSTRUCTIONS BEFORE SHOOTING.



Even a bit of mud, snow or excess lubricating oil or grease in the bore may cause the barrel to bulge, or even burst on firing, and can cause serious injury to the shooter and bystanders. Be sure that you are using ammunition of the proper caliber and loading for the gun you are using. If the report or recoil on firing seems weak, or doesn't seem quite right, CEASE FIRING IMMEDIATELY, unload your firearm, and check to be sure that no obstruction has become lodged in the barrel. Never try to shoot out an obstruction!

5. BE SURE OF YOUR TARGET BEFORE YOU SHOOT.

Don't shoot unless you know exactly where your bullet or shot is going to strike. Be sure of the bullet stop behind your target, even when dry-firing with an unloaded gun. If you are in the field hunting, do not fire at a movement or noise. Take the time to be absolutely certain of your target before you pull the trigger.

6. WEAR SHOOTING GLASSES AND HEARING PROTECTORS WHEN YOU SHOOT.

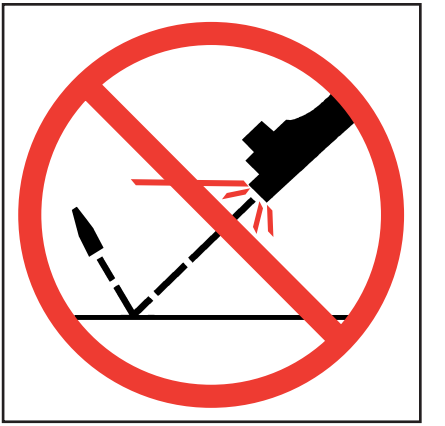
All shooters should wear protective shooting glasses and adequate hearing protectors when shooting. Exposure to shooting noise can damage hearing, and adequate eye protection when shooting is essential.

7. NEVER CLIMB A TREE OR FENCE WITH A LOADED FIREARM.

Put the firearm down carefully before climbing a fence, and unload it before climbing or descending a tree or jumping over a ditch or other obstruction. Never pull or push a loaded firearm toward yourself or another person. When in doubt, or whenever you are about to do anything awkward, unload your gun!

8. DON'T SHOOT AT A HARD SURFACE, OR AT WATER.

Bullets and shot can glance off many surfaces like rocks or the surface of water and travel in unpredictable directions with considerable velocity.



9. NEVER TRANSPORT A LOADED FIREARM.

Firearms should always be unloaded before being placed in a vehicle. A suitable carrying case or scabbard should by used to carry an unloaded firearm to and from the shooting area.

10. AVOID ALCOHOLIC BEVERAGES WHEN SHOOTING.

Don't drink until the day's shooting is over. Handling firearms while under the influence of alcohol in any form, or medications that could affect your judgment or co-ordination, constitutes a criminal disregard for the safety of others.

A BRIEF ACCOUNT OF AN EXTRAORDINARY ACHIEVEMENT: RUGER FIREARMS

One of the few American firearms manufacturers whose management has remained in the same family since starting in business, Sturm, Ruger & Company, Inc., had its beginning in a small machine shop occupying a rented frame building in Southport, Connecticut. In January, 1949, with an initial investment of only $50,000 and an idea, William B. Ruger and Alexander M. Sturm started production of a .22 caliber autoloading pistol–a design which was so successful that it became the cornerstone upon which one of the most comprehensive lines of sporting firearms ever made in America was established. After Alex Sturm's death in 1951, William B. Ruger continued to direct the company alone and today, William B. Ruger, Jr. continues to provide guidance which has made this company a sound and successful enterprise.

Sturm, Ruger & Company, in this relatively short time, has established itself as a leading small arms design organization, developing a unique and broad line of fine quality sporting, military and police firearms to become one of the world's most famous producers of revolvers, pistols, rifles and shotguns. Since 1949 Ruger craftsmen have built many millions of firearms.

During its five decades of growth and progress under the leadership of William B. Ruger, the company developed a business philosophy and implemented policies which represent a constructive influence in the life of modern America. From the beginning, Sturm, Ruger & Company played a positive role in conservation efforts and has supported the interests of shooters through such groups as the National Rifle Association, National Shooting Sports Foundation, and many regional sportsmen's organizations.

The company has always endeavored to market its firearms for constructive and recreational purposes, to emphasize the traditional aspects of shooting, to render meaningful public services and to encourage shooters in constructive, responsible, and safe participation in the shooting sports. Its motto is "Arms Makers For Responsible Citizens."

Today, Sturm, Ruger & Company is particularly mindful of those elements which have contributed to the creation of its success, and extends heartfelt thanks to its many loyal employees and customers.

A current catalog of Ruger firearms is available free upon request to Sturm, Ruger & Co., Inc., Southport, CT 06890

WHY NO WARRANTY CARD HAS BEEN PACKED WITH THIS NEW RUGER FIREARM

The Magnuson-Moss Act (Public Law 93-637) does not require any seller or manufacturer of a consumer product to give a written warranty. It does provide that if a written warranty is given, it must be designated as "limited" or as "full" and sets minimum standards for a "full" warranty. Sturm, Ruger & Company, Inc. has elected not to provide any written warranty, either "limited" or "full", rather than to attempt to comply with the provisions of the Magnuson-Moss Act and the regulations issued thereunder. There are certain implied warranties under state law with respect to sales of consumer goods. As the extent and interpretation of these implied warranties varies from state to state, you should refer to your state statutes. Sturm, Ruger & Company wishes to assure its customers of its continued interest in providing service to owners of Ruger firearms.

STURM, RUGER & Company, Inc.
Southport, Connecticut 06890 U.S.A.
http://www.ruger.com

"Arms Makers For Responsible Citizens" ®

A COPY OF THE INSTRUCTION MANUAL FOR ANY RUGER FIREARM IS AVAILABLE FROM THE FACTORY FREE ON REQUEST. THESE INSTRUCTION MANUALS CONTAIN IMPORTANT WARNINGS WHICH MUST BE UNDERSTOOD BEFORE USING THESE FIREARMS.

"RUGER", the Sturm, Ruger logo, "SINGLE-SIX", "BLACKHAWK", "REDHAWK", "SECURITY-SIX", "SPEED-SIX", "SERVICE-SIX", "BEARCAT", "OLD ARMY", "10/22", "MINI-14", "MINI THIRTY", "RANCH RIFLE", "M77", "77/22", "77/44", "77/50", "GP-100", "SP101", "P-85" and "VAQUERO" are registered U.S. trademarks.
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